

Date: Friday, 23/01/2009 8:47:29 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 45191	
Estimate Number : 12970	
P.O. Number :	Part Number : D35746
This Issue : 23/01/2009 S.O. No. :	Drawing Number : D3574 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42590	Material :
Written By :	Due Date : 30/01/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.01.23</u>	
Comment : Est Rev :A New Issue 07.07.23 EC verified by:JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s)
 lexan sheet

Batch: 109455 1B 9-2-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3574

Dwg Rev: A
 Prog Rev: A 1B 9-2-5

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 9-2-5



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

80910216 (44)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

M-L 09/02/06 (44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:47:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 45191

Part Number: D35746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/09 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with R/N and B/N using a permanent fine point marker, then Stock
Location: PP 47922 91210



SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11 JF

Job Completion



MF
09-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45191
Description: Cabin Floor Protector		Part Number: D3574-6
Inspection Dwg: D3574	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.006	X			
7.38	+/-0.030	7.38	X			
11.00	+/-0.030	11.00	X			
15.25	+/-0.030	15.25	X			
25.87	+/-0.030	25.87	X			
39.75	+/-0.030	39.75	X			
44.75	+/-0.030	44.75	X			
58.38	+/-0.030	58.38	X			
63.50	+/-0.030	63.50	X			
65.25	+/-0.030	65.26	X			
10.25	+/-0.030	10.25	X			
11.87	+/-0.030	11.87	X			
14.75	+/-0.030	14.75	X			
26.00	+/-0.030	26.00	X			
40.87	+/-0.030	40.87	X			
45.00	+/-0.030	45.00	X			
48.00	+/-0.030	48.00	X			
55.13	+/-0.030	55.13	X			
61.25	+/-0.030	61.25	X			
61.88	+/-0.030	61.88	X			
64.63	+/-0.030	64.63	X			
1.13	+/-0.030	1.13	X			
7.63	+/-0.030	7.63	X			
11.00	+/-0.030	11.00	X			
22.10	+/-0.030	22.10	X			
22.50	+/-0.030	22.50	X			
24.50	+/-0.030	24.50	X			
35.13	+/-0.030	35.13	X			

DART AEROSPACE LTD		Work Order: <u>W591</u>
Description: Cabin Floor Protector		Part Number: D3574-6
Inspection Dwg: D3574	Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

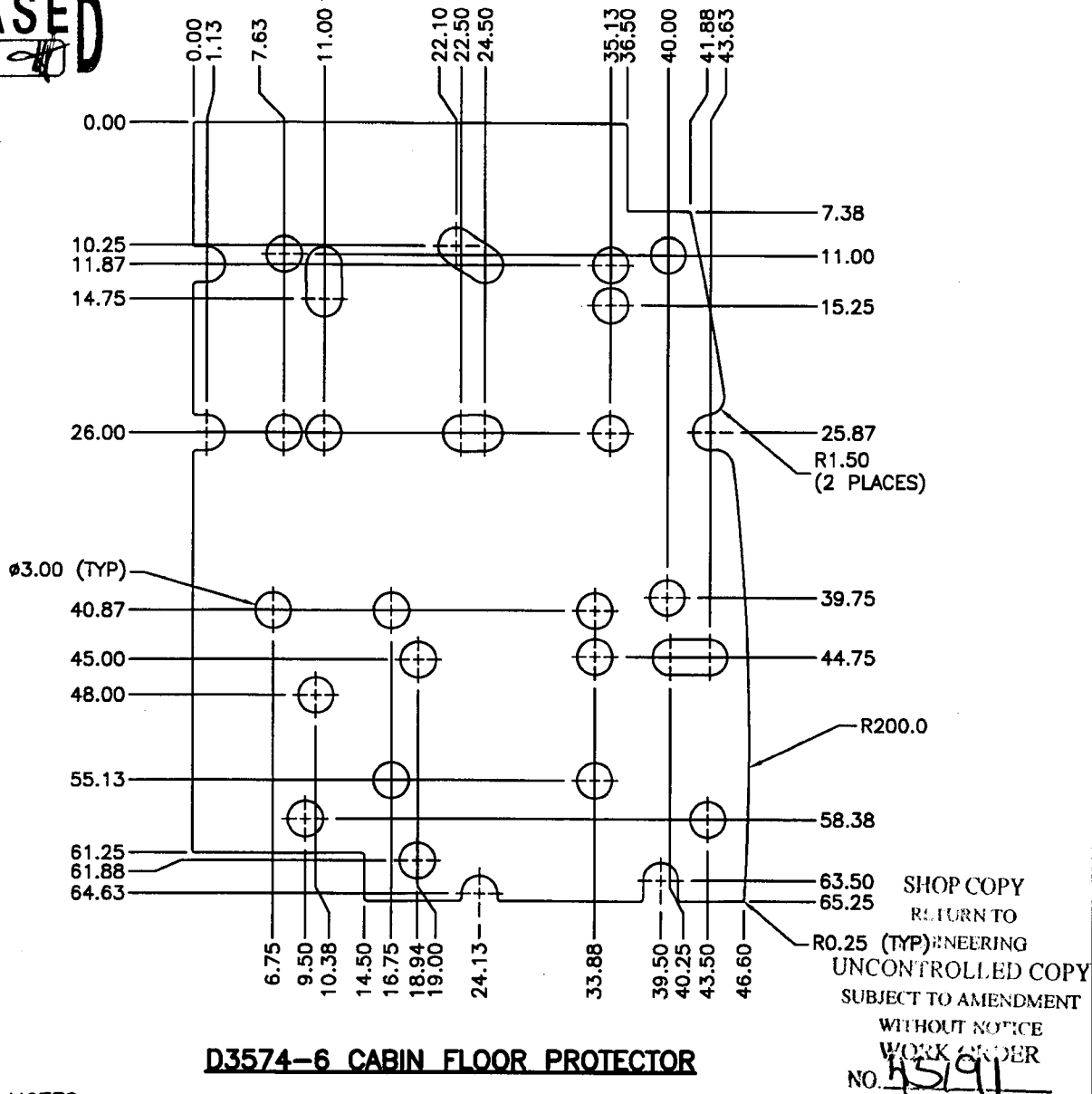
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.50	+/-0.030	36.50	✓			
40.00	+/-0.030	40.00	✗			
41.88	+/-0.030	41.88	✗			
43.63	+/-0.030	43.63	✗			
6.75	+/-0.030	6.75	✗			
9.50	+/-0.030	9.50	✗			
10.38	+/-0.030	10.38	✗			
14.50	+/-0.030	14.50	✗			
16.75	+/-0.030	16.75	✗			
18.94	+/-0.030	18.94	✗			
19.00	+/-0.030	19.00	✗			
24.13	+/-0.030	24.13	✗			
33.88	+/-0.030	33.88	✗			
39.50	+/-0.030	39.50	✗			
40.25	+/-0.030	40.25	✗			
43.50	+/-0.030	43.50	✗			
46.60	+/-0.030	46.60	✗			

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>9-2-5</u>	Date: <u>09/02/06</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD <u> </u>	<u> </u>

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27 *[Signature]***NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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